

Work Order ID 60516

Tuesday, July 13, 2010 11:08:00 AM



Page 1

Item ID: D2654-5

Revision ID:

Item Name: Web

Start Date: 7/13/2010

Start Qty: 1.00

Required Date: 7/14/2010

Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*

Date: *10-7-13*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2654

Rev E1

100



Skid tubes

Skid tubes

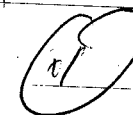
Skid tubes

0.00

Memo

0.00

1-Cut D2600-7 to length as per Dwg D2654 □2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654 □3-Using the uni-bit, open holes to finish size as per Dwg D2654 □4-Deburr holes and ends



ZE 10/07/13

110



QC

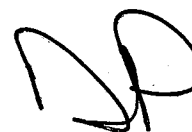
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00



10-7-13

120



Hand Finishing

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00



ZE 10/07/13

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 7/13/2010 Start Qty: 1.00

Required Date: 7/14/2010 Req'd Qty: 1.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

10-7-13

140

Identify as per dwg & Stock Location: LG

0.00

Packaging

Memo

0.00

Packaging

1 BE 10/07/13

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

MF 10-7-13

W/O:			WORK ORDER CHANGES					
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Picklist Print

Tuesday, July 13, 2010 11:08:00 AM

Page 1

Work Order ID: 60516

Parent Item: D2654-5

Parent Item Name: Web



Start Date: 7/13/2010

Required Date: 7/14/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D□99.02.04□Fixed typo, Changed procedure□DM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-7-140		Manufactured	No			100	Each	59.0000	1	1			



EXT. "I BEAM" THICK



Location

LG

41591

Loc Qty

59

59

Loc Code

①

BE 08 10/07/13

W/O:			WORK ORDER CHANGES					
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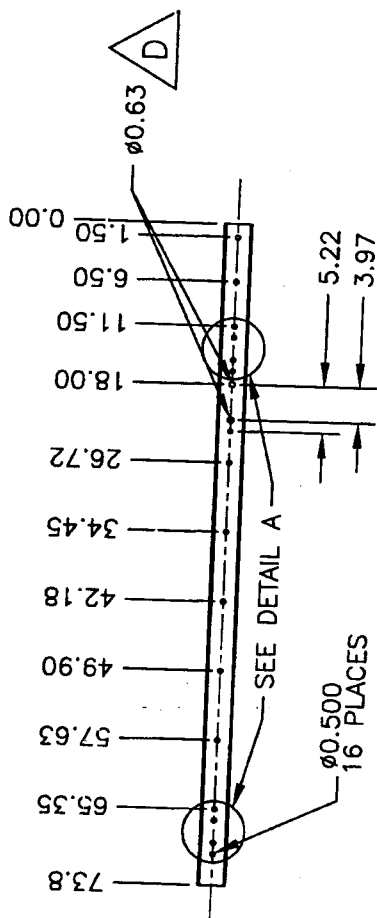
DART
DEO ATTACHED



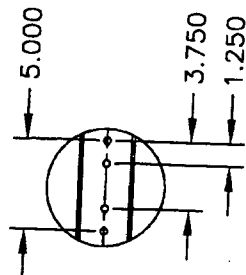
DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT HADLOCK, WA
DATE	04.05.26	DRAWING NO.	D2654	REV. E
		TITLE	WEB	SHEET 1 OF 2
				SCALE 1:20
A	97.03.25	NEW ISSUE		
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29	CHANGED HOLE PATTERN		
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$		
E	04.05.26	CHANGE LENGTHS, REFORMAT		
E1	04.08.04	PER TOOLING; 80.8 WAS 80.5		

RELEASED
04.06.72

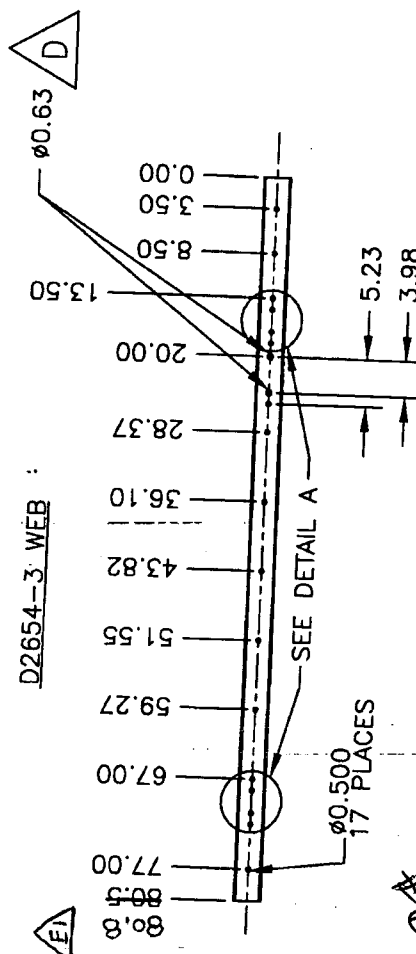
D2654-1 WEB



DETAIL A
SCALE 1:10



D2654-3 WEB



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

2654-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

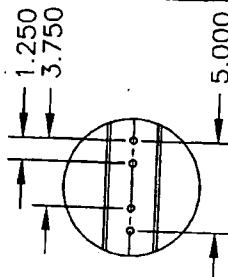


DESIGN UP	DRAWN BY UP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2654	REV. E
DATE 04.05.26		TITLE WEB	SHEET 2 OF 2
		SCALE 1:20	

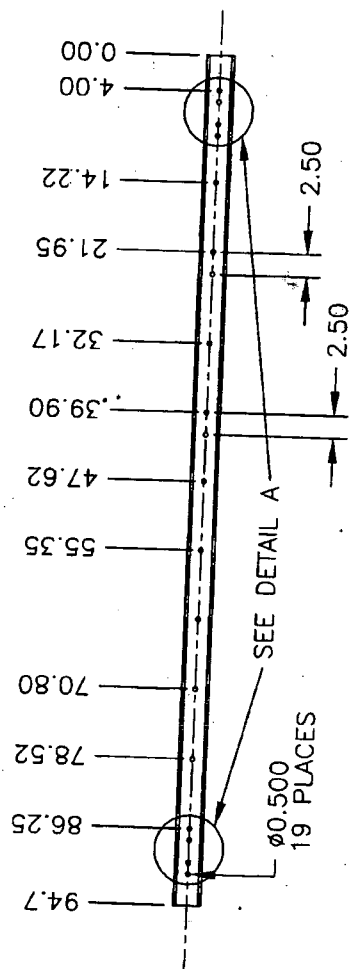
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04.06.22

DEO ATTACHED

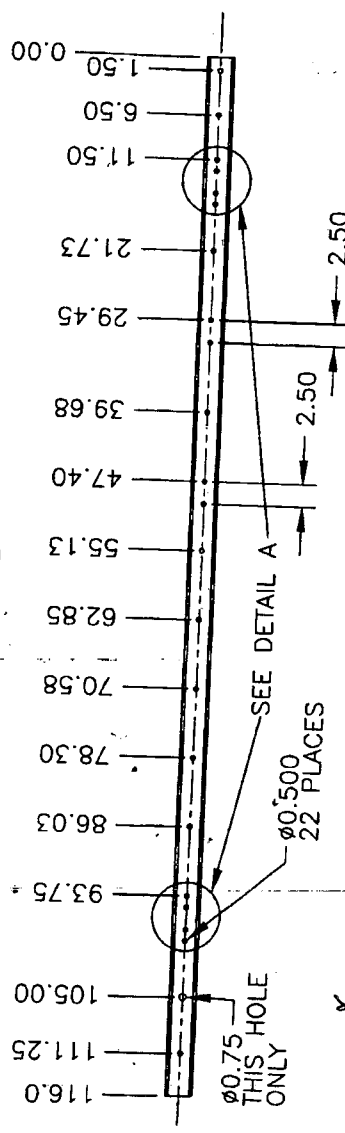
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5161016

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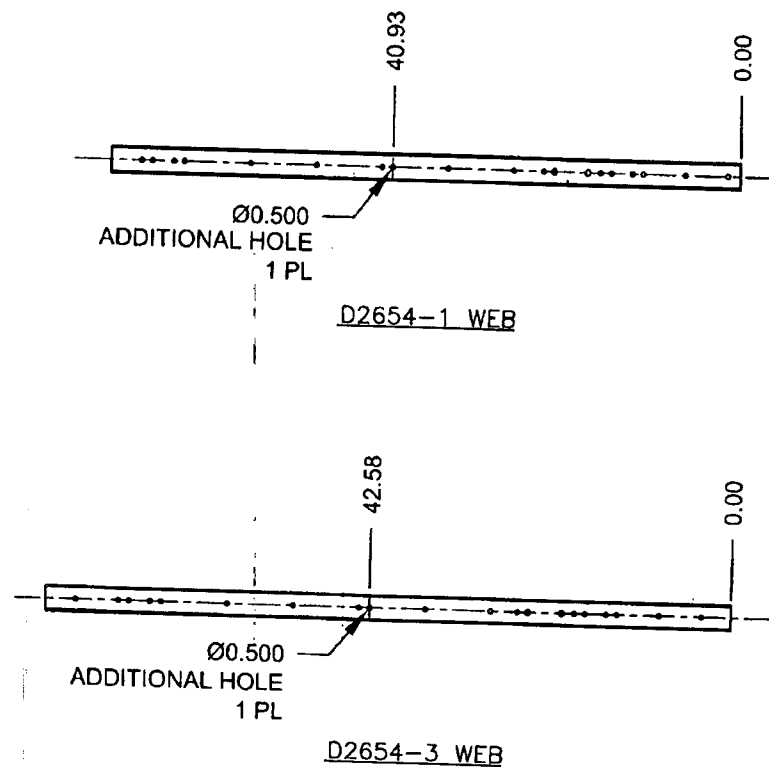
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DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>PH</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>	DE APPR. <i>H</i>			
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03	DATE 09.04.03			

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/08 *MD*



91509#

THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

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